

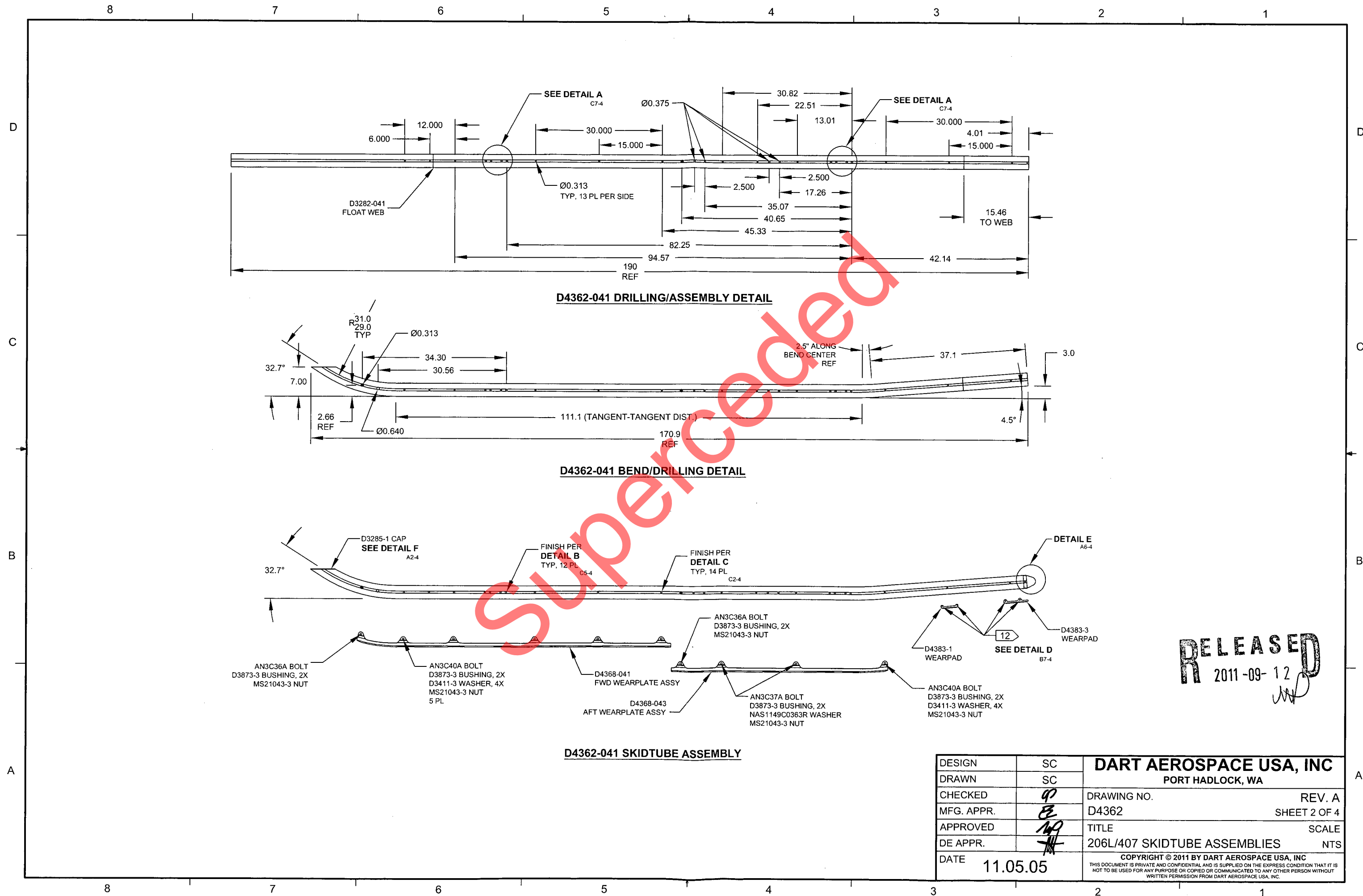
Qty -041	Qty -043	Part Number	Description
X		D4362-041	SKIDTUBE ASSEMBLY
	X	D4362-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
14	39	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
24	24	D3411-3	WASHER
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
20	20	D3873-3	BUSHING
8	8	D3904-1	WASHER
1	1	D4368-041	FWD WEARPLATE ASSY
1	1	D4368-043	AFT WEARPLATE ASSY
1	1	D4383-1	WEARPAD
1	1	D4383-3	WEARPAD
8	8	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
2	2	AN3C36A	BOLT
2	2	AN3C37A	BOLT
6	6	AN3C40A	BOLT
10	10	AN3C4A	BOLT
1	1	AN4C5A	BOLT
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
10	10	MS21043-3	NUT
8	8	NAS1149C0332R	WASHER (OR AN960C10L)
2	2	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0463R	WASHER (OR AN960C416)
2	2	NAS1515H3L	WASHER

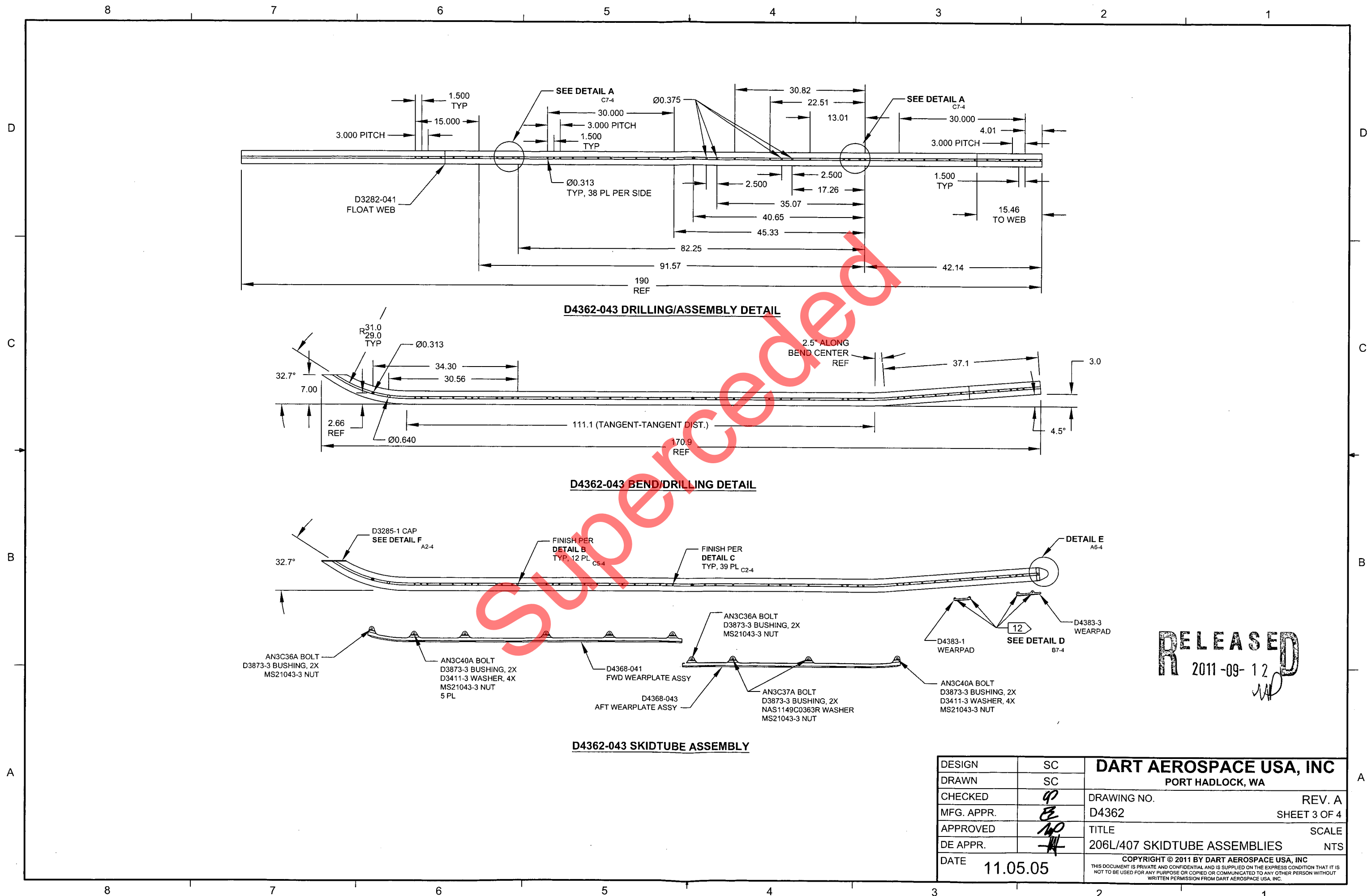
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4362-041 = 54.0 LBS
D4362-043 = 54.3 LBS
- 8) WELD PER DART QSI 004
- 9) ALL HOLES DRILLED ON CENTERLINES.
- 10) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND D3282-041 FLOAT WEB INTO D4362-041/-043 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 12) DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT4362-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/-291.
- 13) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
R 2011-09-12
WP

A	NEW ISSUE		SC	11.05.05
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	SC			
CHECKED	97	DRAWING NO.	REV. A	
MFG. APPR.	EE	D4362	SHEET 1 OF 4	
APPROVED	149	TITLE	SCALE	
DE APPR.	TH	206L/407 SKIDTUBE ASSEMBLIES	NTS	
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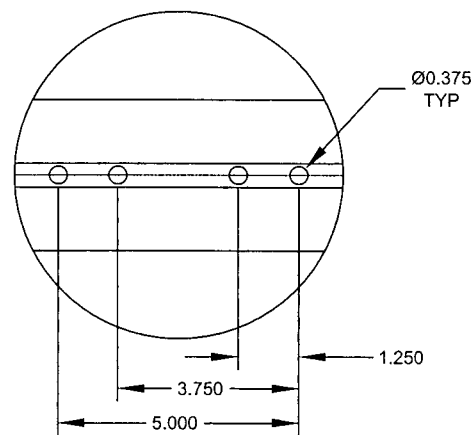
D4362-043 DRILLING/ASSEMBLY DETAIL

D4362-043 BEND/DRILLING DETAIL

D4362-043 SKIDTUBE ASSEMBLY

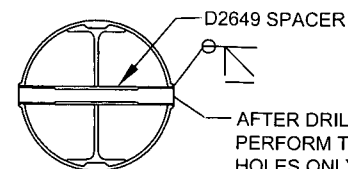
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DRAWN	SC		
CHECKED	9P	DRAWING NO.	REV. A
MFG. APPR.	BE	D4362	SHEET 3 OF 4
APPROVED	160	TITLE	SCALE
DE APPR.	11	206L/407 SKIDTUBE ASSEMBLIES	NTS
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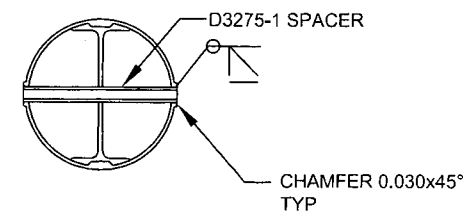
DETAIL A

D3-2
D5-3
D3-3
D5-3



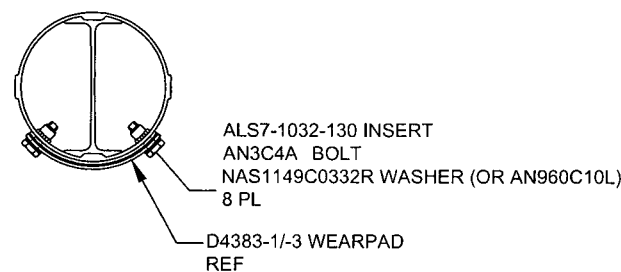
DETAIL B
FOR Ø0.375 HOLES ONLY

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP



DETAIL C
FOR Ø0.313 HOLES ONLY

B4-2
B4-3



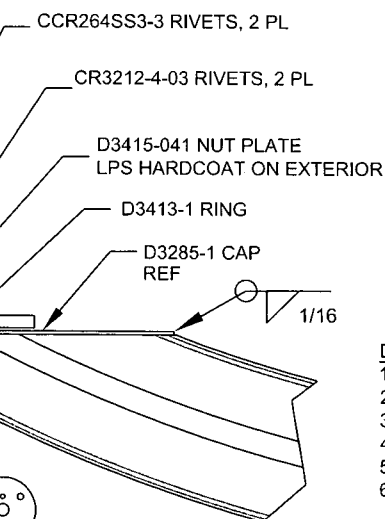
DETAIL D

A2-2
A2-3

AN4C5A BOLT
NAS1149C0463R WASHER (OR AN960C416)
INSTALL WITH SIKAFLEX-241/-291

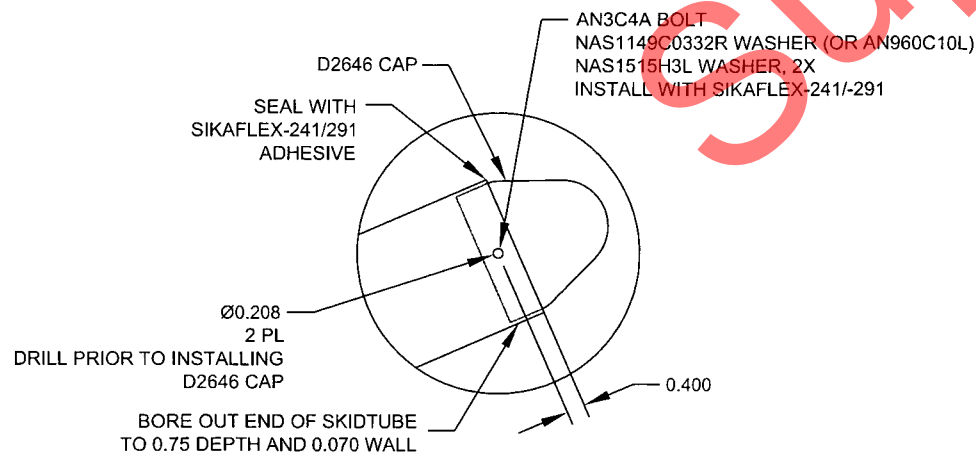
1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041



- DETAIL F NOTES:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH



DETAIL E

B2-2
B2-3

DETAIL F
END FINISHING DETAIL

B6-2
B6-3

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